

WHAT IS CLAIMED IS:

1. A method of manufacturing a color selection electrode structure for a color cathode ray tube, said color selection electrode structure including a pair of support members opposite to each other, elastic members for supporting said support members, while applying a bias to said support members in such a manner that said support members go farther from each other, and a plurality of grille strips each having two ends supported by said support members, said method comprising the steps of:

a) applying a pressure by a pressure member to said support members to be closer to each other which are each a thin plate approximately triangular in cross section, in such a manner that a contact surface of said pressure member which comes into contact with said support members covers a joint between two sides of each of said support members having an approximately triangular shape in cross section;

b) while maintaining said pressure applied in said step a), cooperatively fixing said plurality of grille strips between said support members;

c) releasing said pressure applied to said support members, to cause a tension in each of said plurality of grille strips supported by said support members using resilience of said elastic members; and

d) placing a damper wire to be in contact with each of said plurality of grille strips.

2. The method according to claim 1 which satisfies the expression

$$\alpha/10 > (\gamma/\delta)/\sqrt{\beta} \quad ,$$

where α is a 0.2 % yield strength of an outer wall of a thin plate constituting said support members which is in contact with said pressure member, β is a thickness

of said thin plate, γ is a pressure to be applied by said pressure member, and δ is an area of said contact surface.

3. The method according to claim 1,

5 wherein said support members are predetermined metal thin plates each being bent into an approximately triangular shape in cross section, including:

an outer wall forming an outer surface;

a fixed base wall cooperatively fixed to said elastic members; and

10 an inclined inner wall having an inclination from an inner end portion of said fixed base wall toward said outer wall,

wherein said outer wall has such a structure that a central portion is greater in height than peripheral portions at two ends, whereby an edge of said outer wall has an approximately arc shape, and

wherein said plurality of grille strips are cooperatively fixed along said edge.

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4. The method according to claim 1,

wherein said pressure member used in said step a) comprises:

a pressure element which comes into contact with said support members through surface-to-surface contact; and

20 a pressure rod loosely fitted in said pressure element on the side opposite to said contact surface which is in contact with said support members, said pressure rod pressing said pressure element toward said contact surface while supporting said pressure element in a manner allowing swingable movement of said pressure element in all directions relative to said contact surface.

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5. The method according to claim 4,

wherein a hole is formed on a back surface of said pressure element, whereby a tip of said pressure rod is loosely fitted in said hole,

wherein said pressure rod includes a columnar body, and a spherical or
5 ellipsoidal portion to be inserted in said hole, said portion of said pressure rod being fixed to an end of said columnar body, or being molded in one piece with said columnar body, and

wherein said portion of said pressure rod is smaller in diameter than said hole.